

### **DELO-DUOPOX® 6747**

#### **Base**

- epoxy casting resin
- two-part, not filled, elastic

#### **Use**

- casting applications in electronics
- equalizing, flexible, liquid

#### **Application**

- components A and B must be mixed well or homogenised according to beneath stated mixing ratio
- supplied ready to use and best applied from the original container
- surfaces to be bonded should be dry, free from dust, grease and other contaminants
- DELOTHEN cleaners are recommended for cleaning

#### **Curing**

- at room temperature
- higher temperatures accelerate curing

#### **Technical data**

colour	yellowish
filler	not filled
mixing ratio (A : B) by weight	2 : 1
(A : B) by volume	7 : 4
density [g/cm <sup>3</sup> ] mixture at room temperature (ca. 23 °C)	1.1
viscosity component A [mPas] brookfield at 23 °C	900
viscosity component B [mPas] brookfield at 23 °C	900
viscosity mixture [mPas] brookfield at 23 °C	900
pot life in 100 g preparation [min] DIN EN 14022, at 23 °C	30
pot life in 1 kg preparation [min] DIN EN 14022, at 23 °C	25

processing time in 100 g preparation [min] at 23 °C	35
maximum reaction temperature [°C] in 100 g preparation	140
maximum reaction temperature [°C] in 1 kg preparation	160
curing time until final strength [h] at room temperature (approx. 23 °C)	24
tensile/shear strength Al/Al [MPa] DIN EN 1465, sand-blasted join part thickness: 1.6 mm after 24 h at room temperature (ca. 23 °C)	8
tensile strength [MPa] DIN EN ISO 527	4
elongation at tear [%] DIN EN ISO 527	50
Young modulus [MPa] DIN EN ISO 527	< 10
shore hardness D DIN 53505	37
indentation hardness [MPa] ISO 2039, part 1	58
glass transition temperature [°C] rheometer, curing: 48 h/Raumtemperatur	35
coefficient of elongation [ppm/K] TMA, in a temperature range of +30 to +140 °C	225
coefficient of elongation [ppm/K] TMA, in a temperature range of +45 to +120 °C	209
shrinkage [vol. %] standard DELO 13	1 - 2
water absorption [weight %] DIN EN ISO 62, 24 h at room temperature (approx. 23 °C)	0.4
chemical stability	very good
recommended long-time temperature range of use [°C]	-40 to +120
short-time temperature of use [°C]	+200
specific volume resistance [ $\Omega$ cm] VDE 0303, part 3	1.28xE13
surface resistance [ $\Omega$ ] VDE 0303, part 3	5.29xE12
breakdown voltage [kV/mm] VDE 0303, part 2	> 29.3
dielectric constant VDE 0303, part 4	4.6
creep resistance CTI VDE 0303, part 1, IEC 112	> 600 M

**storage life**

at room temperature (approx. 23 °C) in unopened original container

12 months

**Recommendations****General**

The data and information provided are based on tests performed under laboratory conditions. Reliable information about the behaviour of the product under practical conditions and its suitability for a specific purpose cannot be concluded from this.

It is the user's responsibility to test the suitability of the product for the intended purpose by considering all specific requirements. Type and physical and chemical properties of the materials to be processed with the product, as well as all actual influences occurring during transport, storage, processing and use, may cause deviations in the behaviour of the product compared to its behaviour under laboratory conditions. All data provided are typical average values or uniquely determined parameters measured under laboratory conditions.

The data and information provided are therefore no guarantee for specific product properties or the suitability of the product for a specific purpose.

**Instruction for use**

The instruction for use is available under following address: [www.DELO.de](http://www.DELO.de). If requested we will also be pleased to send it to you.

**Industrial health and safety standards**

see material safety data sheet

**Specification**

see quality assurance certificate